

# Work Order ID 85736

June-14-12 1:55:35 PM

*shy July 6*  
\*85736\*

Page 1

Item ID: D3913-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Long Basket Base Assembly, 350

Start Date: 14/06/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 28/06/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/06/14*

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3913	A								
D4020	A								
100	Weld per dwg A/R S.S. rod Batch: <i>102</i>	0.00							
<b>*100*</b>	Large Fab								
Large Fab	<b>Memo</b>	0.00							
	1- assemble ribs , weld as per dwg D3913 using DT9610A								
	***inspect before welding mesh***								
	2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913								
	and trim mesh to fit if necessary and trim to clear fasteners holes on the ends								
	3- weld hinge (3) and Mounting brackets as per dwg D3913								
	***take lid to locate hinge and bracket***								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
<b>*110*</b>									
QC	<b>Memo</b>	0.00							
Quality Control									

WELDE MESH → *EC 12-7-10*

*1 0 SE 12-07-10*  
*EC 12-07-10*

**\*85736\***

Page 2

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Cust Item ID:**

**Start Date:** 14/06/2012      **Start Qty:** 1.00

**\* 1 \***

**Customer:**

**Required Date:** 28/06/2012      **Req'd Qty:** 1.00

**\* 1 \***

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

### Operation Description

## Set Up/ Run Hours

## Tool ID

### Tool #

**Plan  
Code**

**Accept Qty**

Reject  
Qty

### Reject Number

**Insp.  
Stamp**

120

QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

## Memo

0.00

## Quality Control

125

Pressure Wash per QSI005 4.3

0.00

\*125\*

HandFinish

## Memo

0.00

## Hand Finishing

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>																
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Offset/Setup									
Other									
Process									
Supplier									
Training									
Unauthorized									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>Hardware</b> <input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong  <b>Drill Holes</b> <input type="checkbox"/> Misaligned <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Undersized <input type="checkbox"/> Too Many	<b>General</b> <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing  <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material
---	--	---

<input type="checkbox"/> Set-up
<input type="checkbox"/> Supplier
<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Weld
<input type="checkbox"/> Wrong Stock Pulled
<input type="checkbox"/> Other

**Work Order ID 85736****\*85736\***

Page 3

June-14-12 1:55:35 PM

Item ID: D3913-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Long Basket Base Assembly, 350

Start Date: 14/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 28/06/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
<b>*130*</b>									
Powdercoat									
Powder Coating									
	Memo	0.00							
	1- Plug holes and mask only interior of hinge (3) prior to powder coat								
	1ST COAT:								
	START TIME: <u>1:45</u>								
	OVEN TEMPERATURE: <u>400°F</u>								
	FINISH TIME: <u>2:15</u>								
	***** 2nd coat if necessary*****								
	2ND COAT:								
	START TIME: _____								
	OVEN TEMPERATURE: _____								
	FINISH TIME: _____								
140	QC3- Inspect Part Finish	0.00							
<b>*140*</b>									
QC									
Quality Control	Memo	0.00							

# Work Order ID 85736

June-14-12 1:55:35 PM

**\*85736\***

Page 4

Item ID: D3913-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Long Basket Base Assembly, 350

Stop **\*NS2\***

Start Date: 14/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 28/06/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Assemble as per dwg

0.00

**\*150\***

HandFinish

Memo

0.00

Hand Finishing

Pick Kit

1 0 12-7-10

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

Memo

0.00

Quality Control

8121214

170

Identify as per dwg & Stock Location: D4030-043

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

85732

1 0 12-7-10



**Work Order ID 85736****\*85736\***

Page 5

June-14-12 1:55:35 PM

Item ID: D3913-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Long Basket Base Assembly, 350

Start Date: 14/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 28/06/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

MCS 12/07/11  
MCS 12/07/11

# Picklist Print

June-14-12 1:55:39 PM

Page 1

Work Order ID: 85736

\*85736\*

Parent Item: D3913-041

\*D3913-041\*

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581		Manufactured	No			100	Each	43.0000	2	2			
-------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

✓ \*D2581\*

Mounting Bracket

\*\*

PL12.07.10

Location	Loc Qty	Loc Code
WA	5	
82506	2	
83230	3	
WA005	38	
70766	2	
81253	1	
82897	35	

385436 → (2)

D3913-1		Manufactured	No			100	Each	1.0000	1	1			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

✓ \*D3913-1\*

Rib

\*\*

PL12.07.10

Location	Loc Qty	Loc Code
WA	1	
74145	0	
80790	1	

382917 → (1)

D3913-15		Manufactured	No			100	Each	8.0000	1	1			
----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

✓ \*D3913-15\*

Wide Handle Plate

\*\*

PL12.07.10

Location	Loc Qty	Loc Code
WA	3	
85438	3	
WA005	5	
82919	5	

(1)



# Picklist Print

June-14-12 1:55:39 PM

Page 2

Work Order ID: 85736

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

\*85736\*

\*D3913-041\*

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3913-3

Manufactured No

100

Each

5.0000

1

1

✓ \*D3913-3\*

Rib

\*\*

Location

Loc Qty

Loc Code

WA

4

69160

0

74144

0

82920

3

84651

1

WA006

1

69160

1

Pl 12.07.10  
386140 → ①

D3913-7

Manufactured No

100

Each

13.0000

2

2

✓ \*D3913-7\*

Rib

\*\*

Location

Loc Qty

Loc Code

WA

13

83908

1

85440

12

②

D3913-9

Manufactured No

100

Each

9.0000

1

1

✓ \*D3913-9\*

Hinge Rib

\*\*

Location

Loc Qty

Loc Code

WA

8

84814

3

85292

5

WA006

1

70138

1

①

June-14-12 1:55:40 PM

Shop Packet Print

Page 2

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>																
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Offset/Setup									
Other									
Process									
Supplier									
Training									
Unauthorized									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>Hardware</b> <input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong  <b>Drill Holes</b> <input type="checkbox"/> Misaligned <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Undersized <input type="checkbox"/> Too Many	<b>General</b> <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing  <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material
---	--	---

<input type="checkbox"/> Set-up
<input type="checkbox"/> Supplier
<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Weld
<input type="checkbox"/> Wrong Stock Pulled
<input type="checkbox"/> Other

# Picklist Print

June-14-12 1:55:40 PM

Page 3

Work Order ID: 85736

\*85736\*

Parent Item: D3913-041

\*D3913-041\*

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3916-041

Manufactured No

100

Each

5.0000

2

2

\*\*

✓ \*D3916-041\*

Rib Assembly

Location

Loc Qty

Loc Code

WA

2

84383

2

WA006

3

81444

2

85329

1

B85775 → (2)

D3916-5

Manufactured No

100

Each

15.0000

3

3

\*\*

✓ \*D3916-5\*

Light Rib

Location

Loc Qty

Loc Code

WA

15

77142

1

82933

6

82934

8

B85777 → (3)

D4016-1

Manufactured No

100

Each

13.0000

3

3

\*\*

✓ \*D4016-1\*

Hinge Half, Base

Location

Loc Qty

Loc Code

WA

13

66418

0

84867

13

B85437 → (3)

# Picklist Print

June-14-12 1:55:40 PM

Page 4

Work Order ID: 85736

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

\*85736\*

\*D3913-041\*

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

D4017-7

Manufactured No

100

Each

7.0000

1

1

\*\*

✓ \*D4017-7\*

Rib

## Location

## Loc Qty

## Loc Code

WA

6

82969

6

WA005

1

69730

1

100

Each

13.0000

2

2

\*\*

D4017-9

Manufactured No

✓ \*D4017-9\*

Rib

## Location

## Loc Qty

## Loc Code

WA

7

81445

5

82970

2

WA006

6

70341

2

73531

4

100

Each

17.0000

2

2

\*\*

✓ D4020-11

Manufactured No

\*D4020-11\*

End Mesh, Basket

## Location

## Loc Qty

## Loc Code

WA

-1

81442

2

84972

3

85627

6

WA035

18

85357

6

Pl 12-7-10

B85435 → ①

Pl 12-7-10

B85774 → ②

Pl 12-07-10

②

# Picklist Print

June-14-12 1:55:40 PM

Page 5

Work Order ID: 85736

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

\*85736\*

\*D3913-041\*

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

D4021-1

Manufactured No

100

Each

9.0000

3

3

\*D4021-1\*

Handle Plate

\*\*

## Location

## Loc Qty

## Loc Code

WA

9

69518

0

74316

0

74946

0

85439

9

B85652 → ③

D4034-041

Manufactured No

100

Each

3.0000

1

1

\*D4034-041\*

Aft Upper Rib Assembly

\*\*

## Location

## Loc Qty

## Loc Code

WA006

3

81435

3

B81436 → ①

D4034-043

Manufactured No

100

Each

3.0000

1

1

\*D4034-043\*

Fwd Upper Rib Assembly

\*\*

## Location

## Loc Qty

## Loc Code

WA

3

81174

2

83756

1

B82979 → ①

# Picklist Print

June-14-12 1:55:41 PM

Page 6

Work Order ID: 85736

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

\*85736\*

\*D3913-041\*

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100

sf

713.4864

33

33

\*\*

\*M304EX0 75-16F\*

Expanded Metal Flat SS

*Pl 12.07.10*

Location

Loc Qty

Loc Code

WA

4.9094

121738

4.9094

WA035

708.5769637

117197

102.9036

120917

101.57273

121521

0.00013372

121849

184.1005

122080

320

33

AN3-10A

Purchased

No

150

Each

139.0000

6

6

\*\*

\*AN3-10A\*

Bolt

*sp*

Location

Loc Qty

Loc Code

GA

8

119084

8

ST351

131

117795

2

120873

129

6

AN960JD8

NAS1149DN832

Purchased

No

150

Each

0.0000

2

2

\*\*

\*AN960JD8\*

Washer

D2931

Manufactured

No

150

Each

410.0000

2

2

\*\*

\*D2931\*

Bumper

*M120 422 sp*

*12/7/10 sp*

Location

Loc Qty

Loc Code

ST504

410

46064

410

*2*

June-14-12 1:55:41 PM

Shop Packet Print

Page 6

# Picklist Print

June-14-12 1:55:41 PM

Page 7

Work Order ID: 85736

\*85736\*

Parent Item: D3913-041

\*D3913-041\*

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

D4021-5

Manufactured No

150

Each

10.0000

2

2

\*\*

\*D4021-5\*

Blanking Plate

85891

## Location

## Loc Qty

## Loc Code

ST083

2

84984

2

ST084

8

85065

8

MS20600-AD4W3

Purchased

No

150

Each

740.0000

2

2

\*\*

\*MS20600-AD4W3\*

Cherry Rivets

## Location

## Loc Qty

## Loc Code

ST321

607

111636

36

117601

3

118626

310

120308

258

WA018

133

107939

133

MS21042L3

Purchased

No

150

Each

1,748.000

6

6

\*\*

\*MS21042L3\*

Nut

12/17/10

## Location

## Loc Qty

## Loc Code

ST300

1748

115835

4

117885

32

119017

816

119075

138

121349

23

121444

735

June-14-12 1:55:41 PM

Shop Packet Print

Page 7

# Picklist Print

June-14-12 1:55:41 PM

Page 8

Work Order ID: 85736

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

\*85736\*

\*D3913-041\*

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

150

Each

1,152.000

12

12

**\*NAS1149F0332P\***

WASHER

\*\*

*sf* *12/1/12*

Location

Loc Qty

Loc Code

ST275

1152

117735

13

119225

10

120986

200

121259

200

121825

126

122063

600

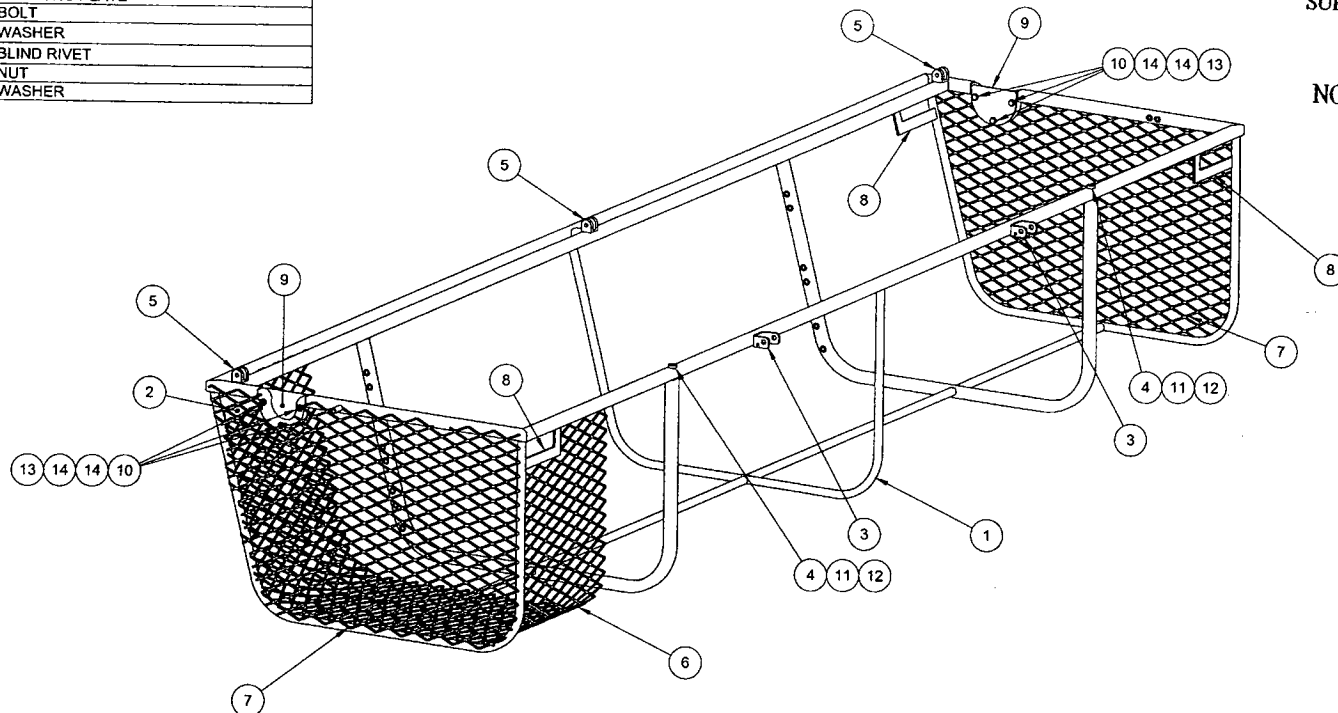
17317

3

*12*



ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN980JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

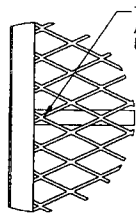
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 85736 MJS

12/06/14

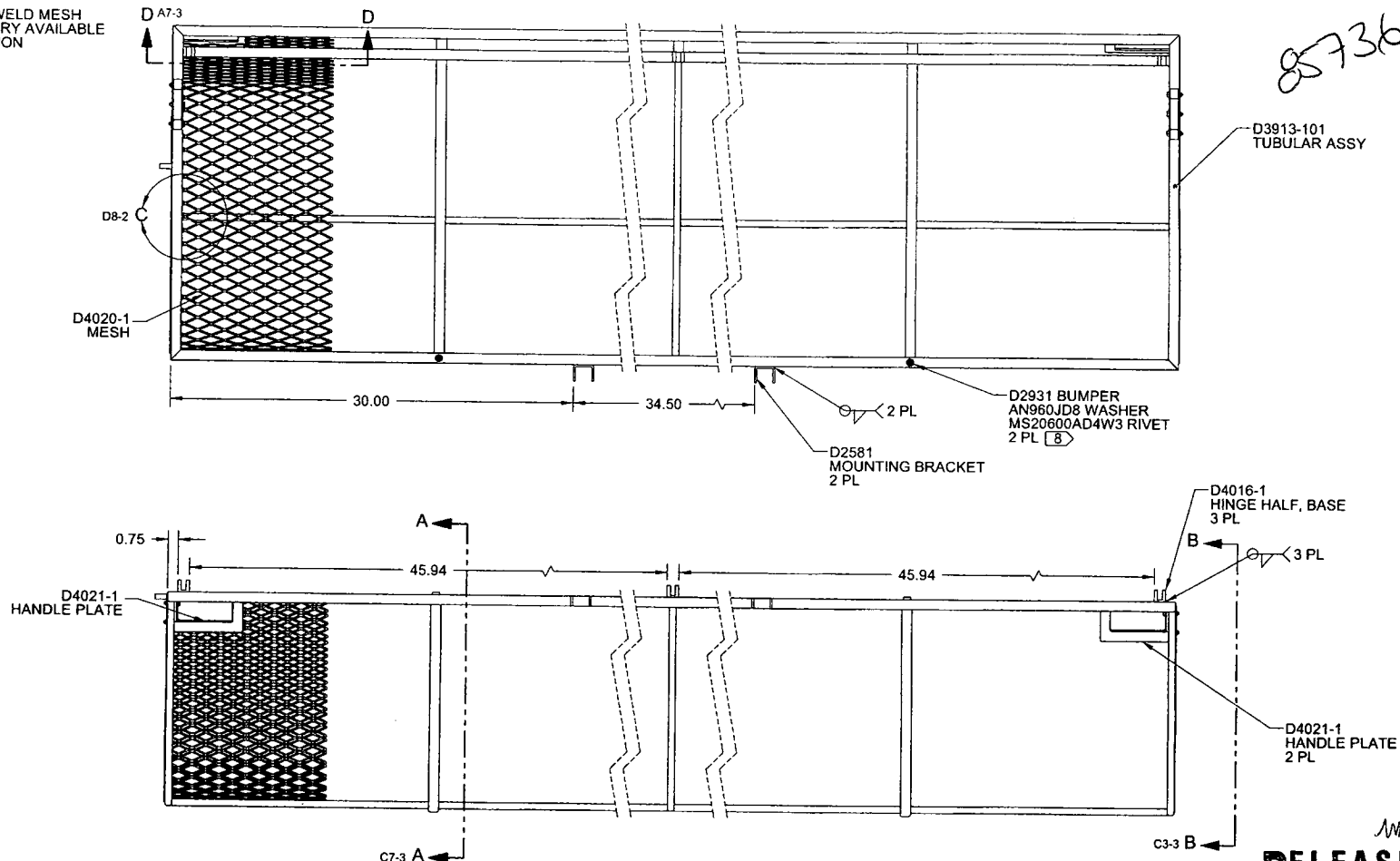
**RELEASED**  
2010-03-22  
JPH

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3913</b>	REV. A SHEET 1 OF 6
TITLE <b>LONG BASKET BASE ASSY (350) NTS</b>	SCALE
COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



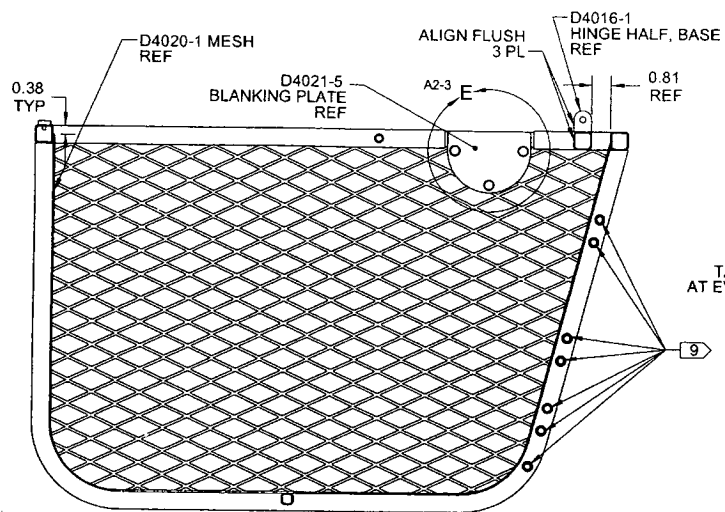
**DETAIL C** D7-2



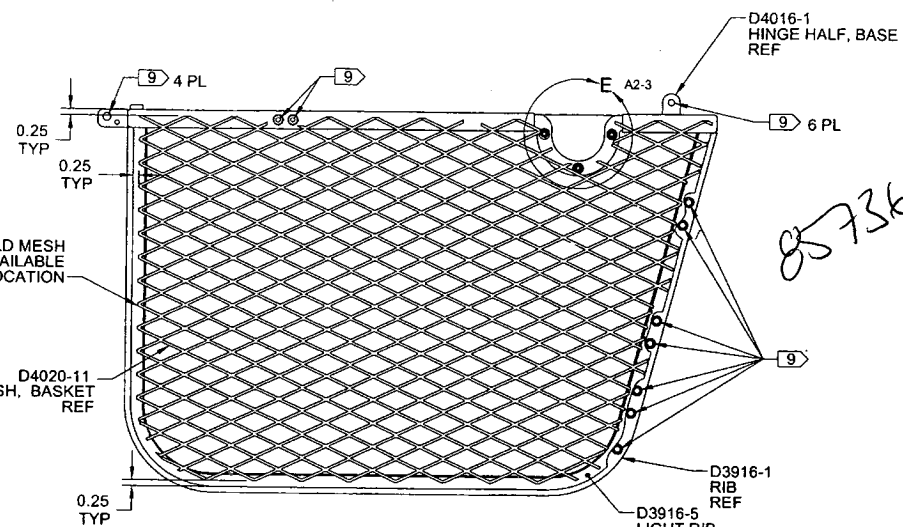
**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
2010-03-16

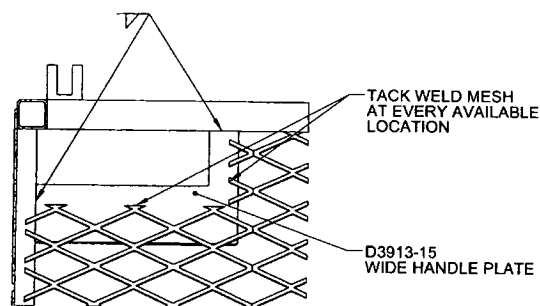
DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3913</b>	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		<b>LONG BASKET BASE ASSY (350) NTS</b>	
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



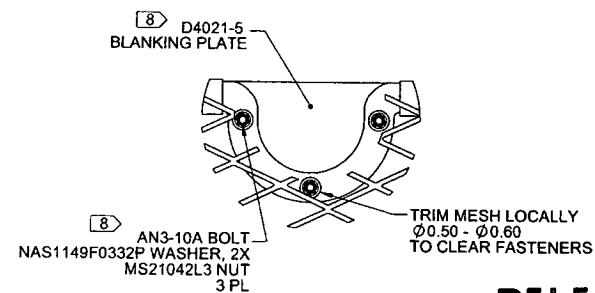
**SECTION A-A** A5-2



**VIEW B-B** A2-2



**SECTION D-D** D7-2  
TYPICAL FOR ALL  
HANDLE PLATES

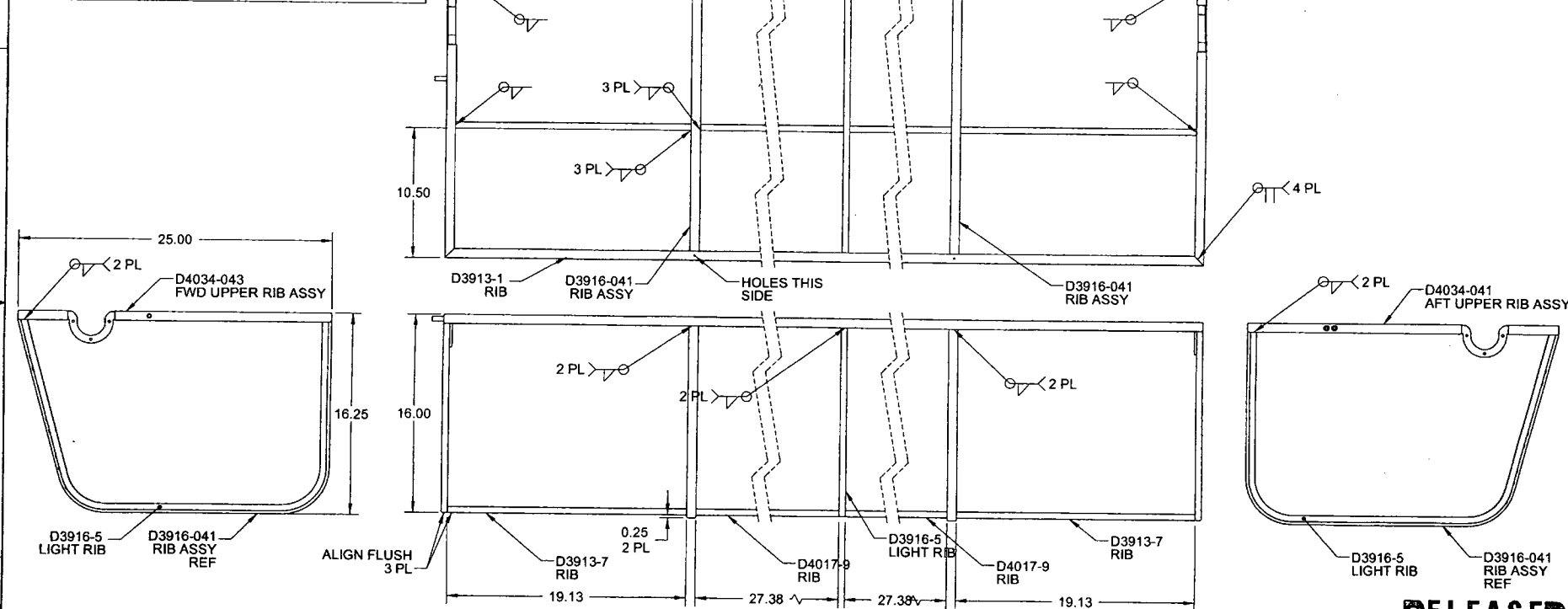


**DETAIL E** D2-3  
D6-3

**RELEASED**  
2010-03-22

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



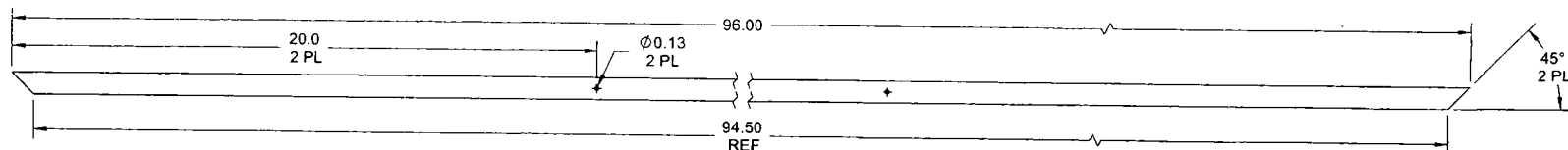
8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D3913-101
- 9) WELD PER DART QSI 004

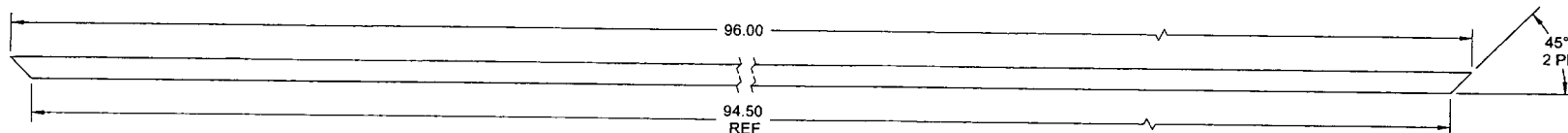
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JRH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED  
2010-03-22

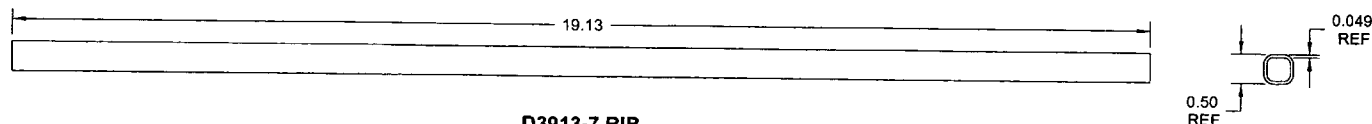


**D3913-1 RIB**

85736



**D3913-3 RIB**



**D3913-7 RIB**



**D3913-9 HINGE RIB**

**NOTES:**

1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

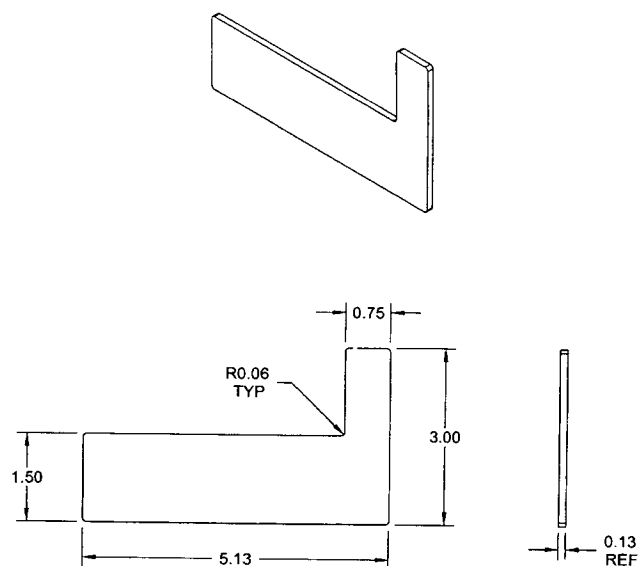
6) IDENTIFICATION: N/A

7) WEIGHT: SEE ASSEMBLED WEIGHTS

**RELEASED**  
2010-03-22

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

85736



**D3913-15 WIDE HANDLE PLATE**

**NOTES:**

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

**RELEASED**  
2010-03-22  
JWP

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JRH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	